

Date: Tuesday, 07/04/2009 10:24:20 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SHORT STEP ASSEMBLY HIGH SKID LH
Job Number : 46997	
Estimate Number : 10575	
P.O. Number :	Part Number : D350591213
This Issue : 07/04/2009 S.O. No. :	Drawing Number : D3078 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 45341	Material :
Written By :	Due Date : 30/04/2009 Qty: 4 Um: Each
Checked & Approved By : <u>JUD 09-04-07</u>	
Comment : Est Rev:B 05.10.14 Modified step 10 KJ/EC	
Est Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM	
Est Rev:C 06-06-27 Revised as per DSI9340 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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for JUD 09/04/30

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-213 CHG002

S 02/04/30

✓ 2.0	D2622120C	Step Extrusion
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**Comment:** Qty.: 0.5000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

1 D2622-120C

Description Batch

Extrusion *B45444*

*(used 1 and first was dated)
 total 4*

SAD 09-04-15 (4)

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078

2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.

3-Deburr

SAD 09-04-15 (4)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP.

S 09/04/15 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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*Job Number: 46997

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D30671	End Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3067-1 End Plate 346334

PH 09-04-20 4

6.0	D30631	Support
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3063-1 Support 344162

PH 09-04-20 4

7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg D3072

A/R Aluminum Rod M110130
M110431

3-Grind End Plate flush

PH 09-04-20 4
PH 09-04-20 4
SAD 09-04-20 4

8.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

DE 09-04-20 4

9.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 09/04/20 444

10.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 09-04-20 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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* Job Number: 46997

Part Number: D350591213

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(4X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 09/04/21

12.0

D3065041

Step Leg Assembly Hi



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3065-041

Step Leg Assy

B45395

SAD

09-04-21

(4)

13.0

D30661

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3066-1

Spacer

B44567

SAD

09-04-21

(4)

14.0

MS20600AD4W4

Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 MS20600AD4W4

Rivet

M111369

SAD

09-04-21

(4)

15.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Rivet Leg Assembly as per Dwg D3078.

SAD

09-04-21

(4)

16.0

QC5

INSPECT WORK TO CURRENT STEP



(X44)

Comment: INSPECT WORK TO CURRENT STEP

09/04/21

17.0

D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3067-1

End Plate

B46334

09-04-23 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 46997

Part Number: D350591213

Job Number:



Seq. #: Machine Or Operation: Description :

18.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3078
A/R Aluminum Rod M110130

4-Grind End Plate flush

Handwritten: 09-04-23 4
09-04-23 4
09-04-23 4
SAN 09-04-24 (4)

19.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Handwritten: PD 09-04-27

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 09/04/27 (44)

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch Up Chemical conversion

Handwritten: UMD/ FL

Handwritten: 09/04/28

Handwritten: (XY)

22.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Handwritten: M109990

Handwritten: Pressure WASH

Handwritten: UMD/

Handwritten: 09/04/29 (24)

START TIME:

Handwritten: 10:05

OVEN TEMPERATURE:

Handwritten: 400° 320°

FINISH TIME:

Handwritten: 10:35

Handwritten: UMD/ FL

Handwritten: 09/04/29 (4)

23.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3078 and QSI 005 4.4

Handwritten: M11013

Handwritten: FL

Handwritten: 09/04/29

Handwritten: (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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*Job Number: 46997

Part Number: D350591213

Job Number:



Seq. #: Machine Or Operation: Description :

24.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



9/4/30
SLY (UK)

Comment: Inspect Powder Coat and Wing Walk

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

26.0

D22301

Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2230-1

Clamp

B46427

9/4/30

SO

27.0

D22303

Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2230-3

Clamp

B46516

9/4/30

SO

28.0

D2732

Rubber Extrusion



Comment: Qty.: 1.0500 f(s)/Unit Total : 4.2000 f(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 D2732-030(3" LONG)

Rubber Cushion

B38509

9/4/30

SO

29.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 2.4000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2856-400(7.2")

Abrasion Strip

B46543

9/4/30

SO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 46997

Part Number: D350591213

Job Number:



Seq. #: Machine Or Operation: Description :

30.0 AN335A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN3-35A Bolt M1106167

9/4/30

SC

31.0 AN411A Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 AN4-11A Bolt M106605

9/4/30

SC

32.0 AN413A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

Batch: M110731

9/4/30

SC

33.0 AN960JD10 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10 Washer M110985

9/4/30

SC

34.0 AN960JD416 Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN960JD416 Washer M110363

9/4/30

SC

35.0 MS21042L3 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3) M110844

9/4/30

SC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 46997

Part Number: D350591213

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

MS21042L4

Nut



(44)

Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS21042L4

Nut (or -4)

M110450

9/4/30

SP

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

509/04/30

(44) CH

38.0

PACKAGING 1

PACKAGING RESOURCE #1



(44)

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-213

Location: 80

PPP Rev: SD

9/4/30

SP

39.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/01

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-05-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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DATE 02.09.11		TITLE STEP ASSEMBLY, HI SHORT SCALE NTS	
A	02.09.11	NEW ISSUE	

RELEASED
02.09.20 *#*

Part No.	Description	QTY -041	QTY -042
D3078-041	Step Assembly, High Short (LH)	X	
D3078-042	Step Assembly, High Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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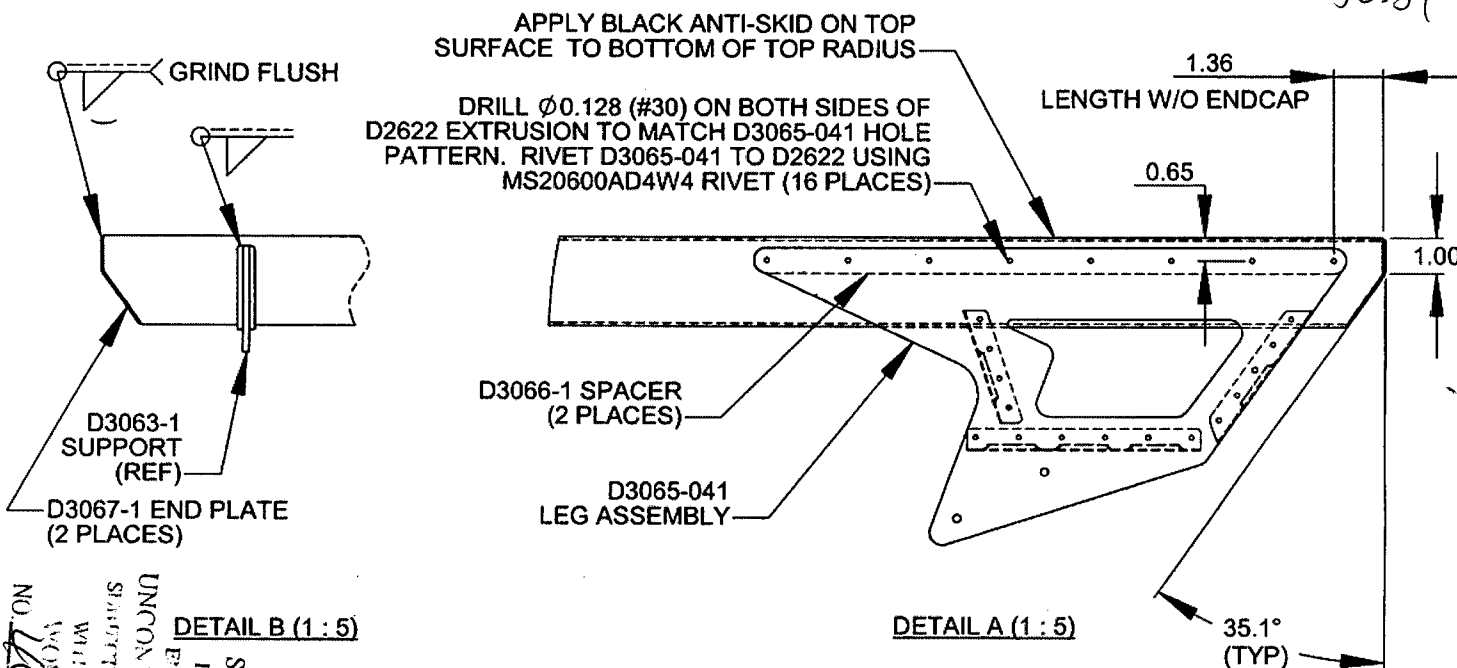
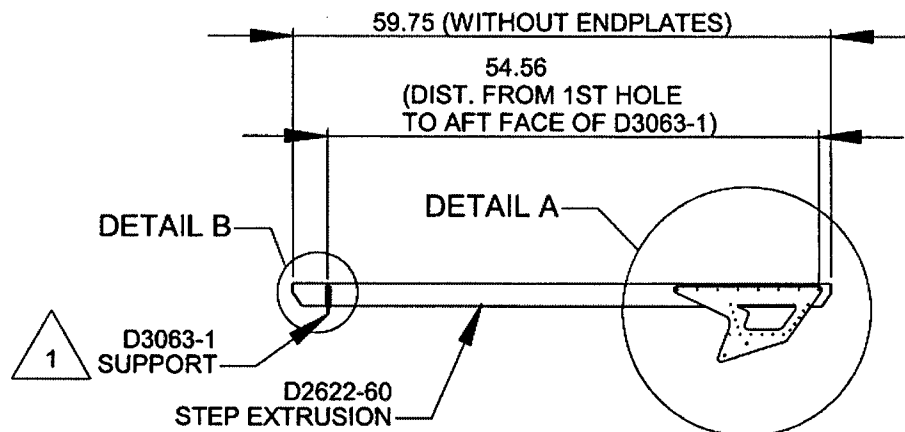
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DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. A
02.09.11	STEP ASSEMBLY, HI SHORT	SHEET 2 OF 2
		SCALE 1:20

RELEASED
02.09.2011



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